

Work Order ID 71880

Wednesday, July 13, 2011 11:08:36 AM



Page 1

Item ID: D3407-3

Accept



Setup Start



Revision ID:

Item Name: Stem

Stop



Start Date: 7/14/2011 Start Qty: 20.00



Cust Item ID:

Required Date: 7/28/2011 Req'd Qty: 20.00



Customer:

Reference:

Approvals:	Process Plan:	MF	Date:	11-07-13	Tooling:		Date:		Run	Start	
	QC:		Date:		SPC (Y/N):		Date:		Stop		



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
D3407	Rev E

100 0.00

DOOSAN LATHE

Doosan

Doosan Lathe

Memo 0.00

1-Turn as per Folio FA597 Rev: AA & Dwg D3407 Rev: E

□2-Deburr

20

110 0.00

QC

Quality Control

Memo 0.00

11/8/18

20

120 0.00

QC

Quality Control

Memo 0.00

10/8/18

20 11. 8. 10

20

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 71880

Page 2

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Accept



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Revision ID:

Item Name: Stem

Stop



Start Date: 7/14/2011 Start Qty: 20.00



Cust Item ID:

Required Date: 7/28/2011 Req'd Qty: 20.00



Customer:

Reference:

Approvals: Process Plan: _____

Date: _____

Tooling: _____

Date: _____

Run Start



QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop

Sequence ID/
Work Center ID

130



Packaging

Packaging

Operation
DescriptionIdentify as per dwg & Stock Location WFSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

0.00

11/18/10

SL

20

140



QC

Quality Control

QC21- Final Inspection - Work Order Release

0.00

Memo

0.00

CK 11/08/10

11-08-10
(20)

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Picklist Print

Page 1

Wednesday, July 13, 2011 11:08:34 AM

Work Order ID: 71880



Parent Item: D3407-3



Parent Item Name: Stem

Start Date: 7/14/2011

Required Date: 7/28/2011

Start Qty: 20.00

Required Qty: 20.00

Comments:

IPP Rev:A 05.10.18 New issue KJ/EC

IPP Rev:B Now on Doosan 08-05-14 JLM Verified By:DD

IPP Rev:C 08-08-12 revE as per dwg (ecn 08-507) DD verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M174R0.750		Purchased	No			100	f	6.4650	0.366	7.705263			

17-4 round bar .750



Location

MAT030

117683

Loc Qty

6.465

6.465

Loc Code

118483

8 ft

M174R0.750
M118483

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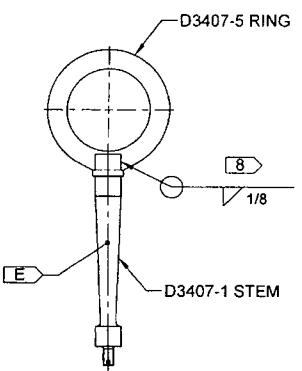
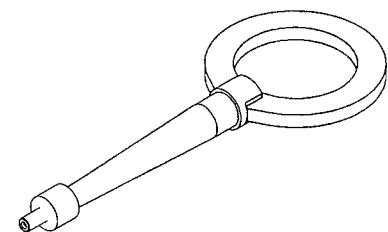
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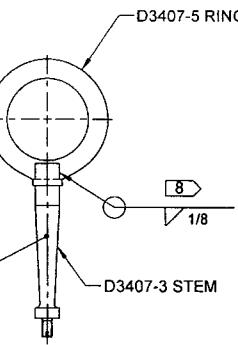
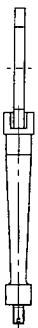
8 7 6 5 4 3 2 1

E

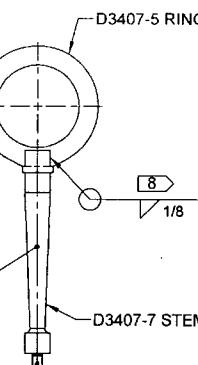
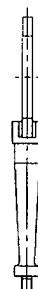
QTY -041	QTY -043	QTY -045	PART NUMBER	DESCRIPTION
X			D3407-041	TOW RING
	X		D3407-043	TOW RING
		X	D3407-045	TOW RING
1			D3407-1	STEM
	1		D3407-3	STEM
1	1	1	D3407-5	RING
		1	D3407-7	STEM



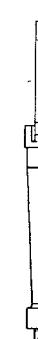
D3407-041 TOW RING



D3407-043 TOW RING



D3407-045 TOW RING



#71860
RELEASED
01-08-2004

A NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: POWDER COAT WHITE (4.3.5.2) PER DART QSI 005 4.3 (EXCEPT THREADS)
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3407-XXX" USING BLACK FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: D3407-041 - 0.60 lbs, D3407-043 - 0.53 lbs, D3407-045 - 0.61 lbs
- 8) WELD PER DART QSI 004 ON ALL EDGES BETWEEN STEM AND RING

8 7 6 5 4 3 2 1

E	ADD D3407-045 (ZN B2-1, D8-1); ADD D3407-7 (ZN B6-5); REVISED NOTE 6 TO ADD IDENTIFICATION (ZN A5-1); REASON: PRODUCTION FACILITY	PH	08.07.23
D	D3407-1/3 SLOT WAS ROUND NOW FLAT FOR ASSEMBLY WITH D3407-5 (ZN C2-2, C2-3); D3407-5 WAS ROUND NOW FLAT ON ONE END FOR ASSEMBLY WITH D3407-1/3 (ZN B6-4); REASON: PRODUCTION FACILITY	PH	08.04.07
C	-1/3 LONGER FOR FIT W/WASHER	CP	05.09.09
B	UPDATE DIAMETER, THREAD CLASS ADDED	CP	05.06.17
A	NEW ISSUE	CP	05.03.16
REV.	DESCRIPTION	BY	DATE
DESIGN	<i>10</i>	DART AEROSPACE USA, INC.	
DRAWN	<i>10</i>	PORT HADLOCK, WA	
CHECKED	<i>10</i>	REV. E	
MFG. APPR.	<i>10</i>	DRAWING NO.	
APPROVED	<i>10</i>	D3407	SHEET 1 OF 5
DE APPR.	<i>10</i>	TITLE	SCALE
		TOW RING	
		NTS	
	DATE	08.07.23	

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8 7 6 5 4 3 2 1

1

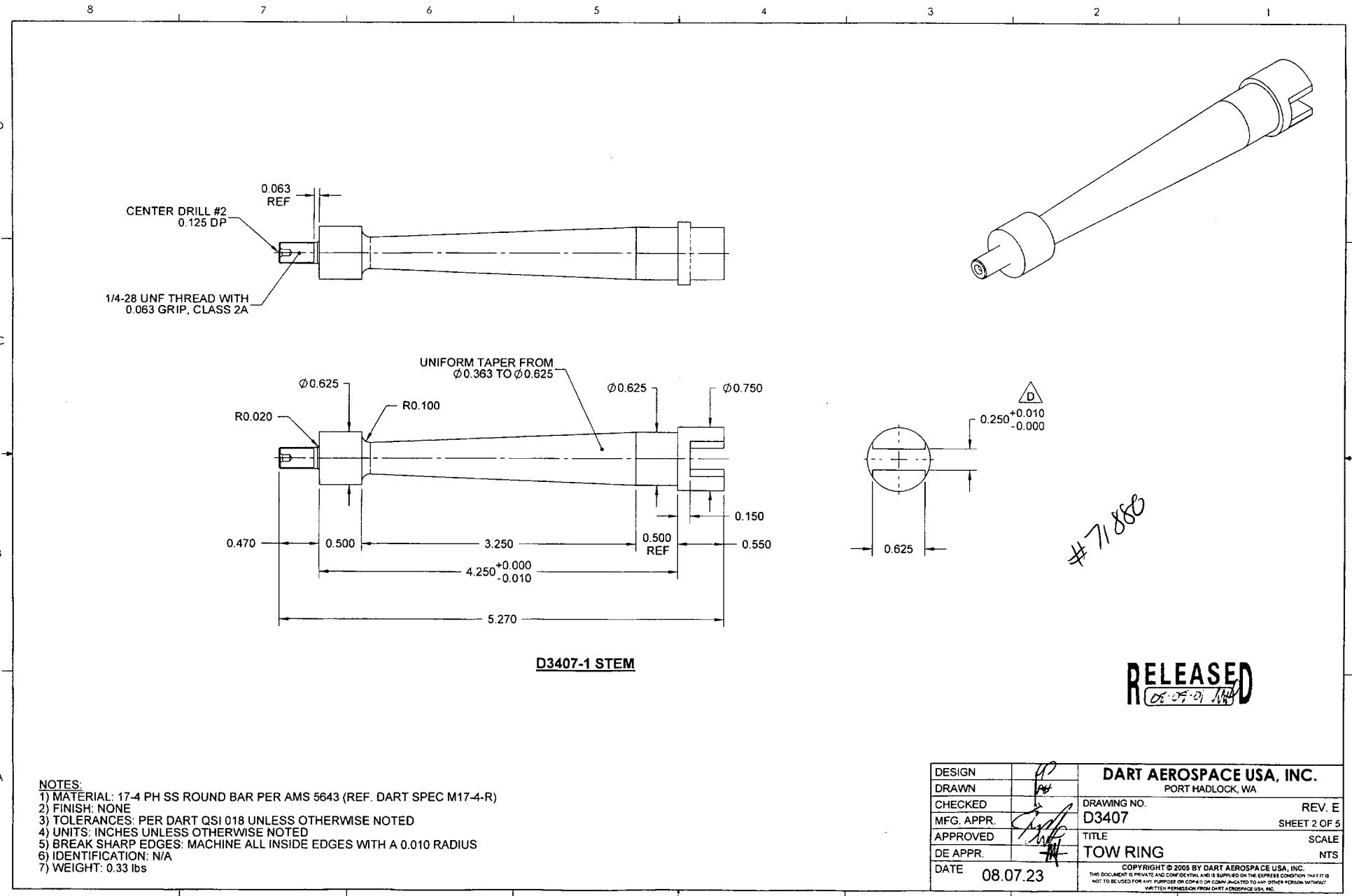
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DESIGN	10	DART AEROSPACE USA, INC.
DRAWN	10	PORT HADLOCK, WA
CHECKED	10	DRAWING NO. D3407
MFG. APPR.	10	REV. E
APPROVED	10	SHEET 2 OF 5
DE APPR.	10	TITLE TOW RING
DATE	08.07.23	SCALE NTS

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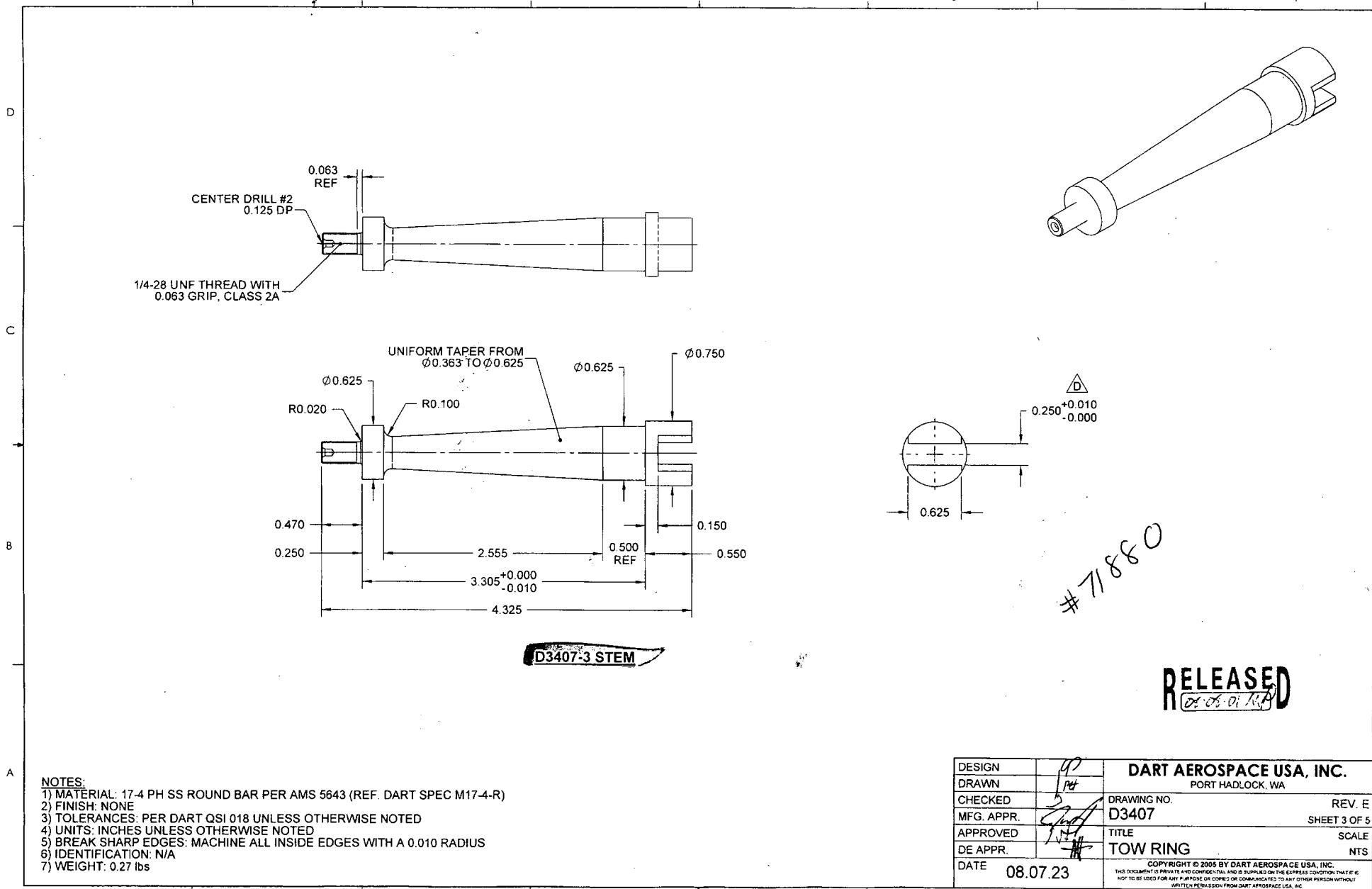
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8 7 6 5 4 3 2 1



DESIGN	97	DART AEROSPACE USA, INC.
DRAWN	1st	PORT HADLOCK, WA
CHECKED	5	DRAWING NO. D3407
MFG. APPR.	✓	REV. E
APPROVED	✓	SHEET 3 OF 5
DE APPR.	✓	TITLE TOW RING
DATE	08.07.23	SCALE NTS

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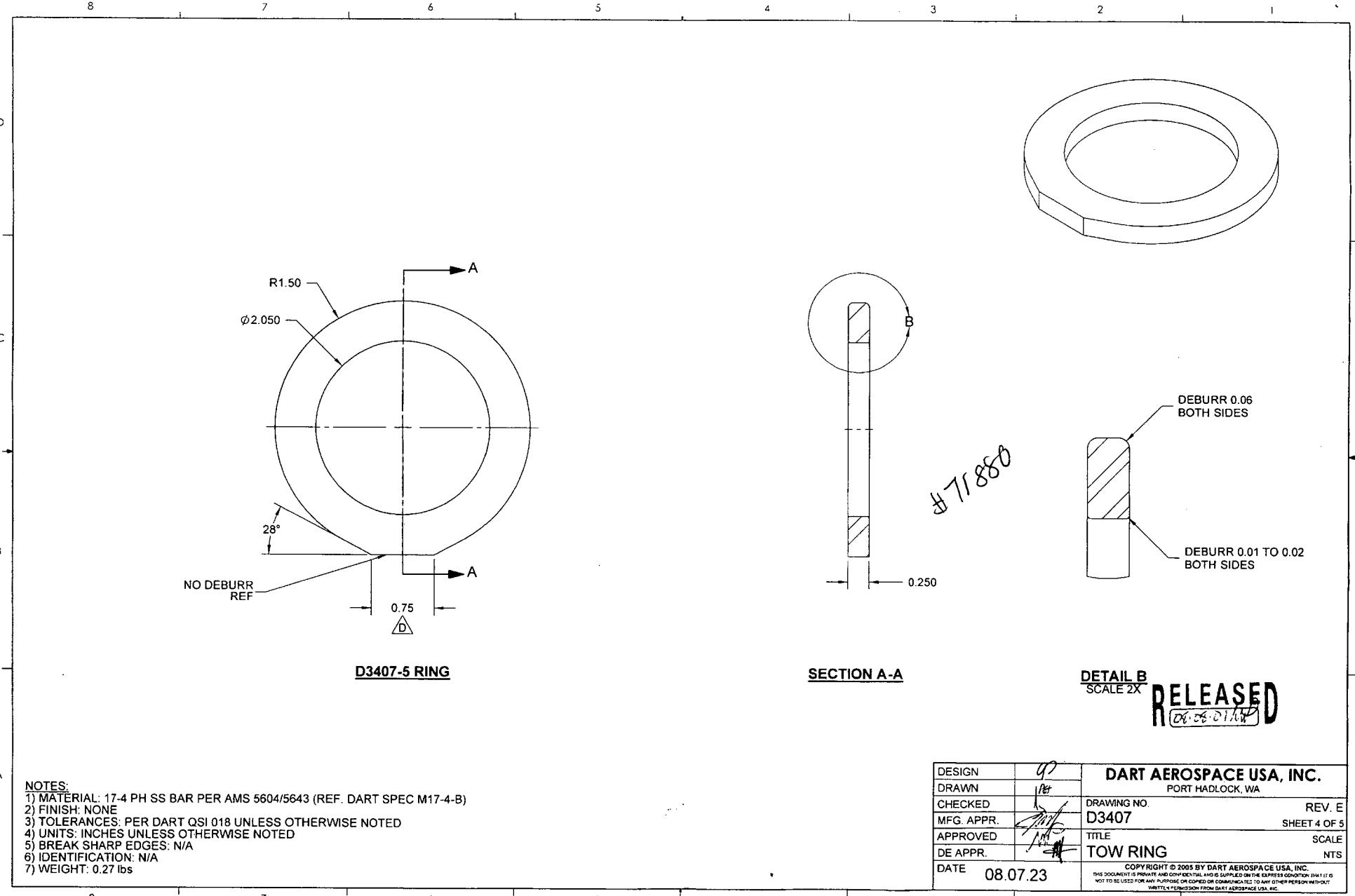
8 7 6 5 4 3 2 1

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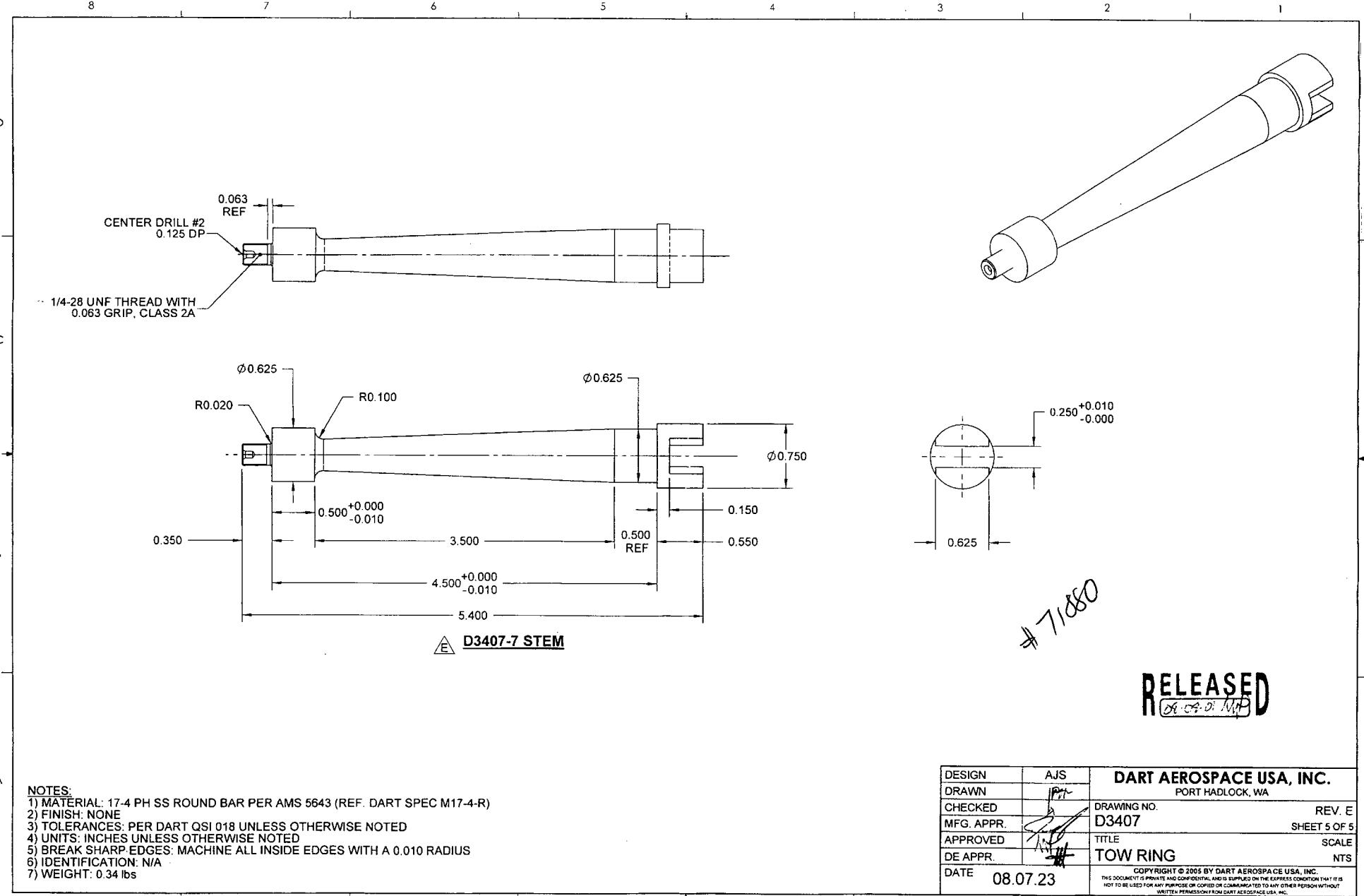
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DART AEROSPACE LTD	Work Order:	71880
Description: Stem	Part Number:	D3407-3
Inspection Dwg: D3407	Rev: E	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X First Article Prototype

Measured by: <u>SJ</u>	Audited by: <u>RP</u>	Prototype Approval:	N/A
Date: <u>1/8/18</u>	Date: <u>11-8-10</u>	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	06.11.08	New Issue	KJ/JLM	
B	07.09.26	Tolerances revised	KJ/EC	
C	08.05.14	Dimensions updated per Dwg Rev D	KJ/JLM	
D	08.10.07	Dimensions updated per Dwg Rev E	KJ/DD	✓

W/O:

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